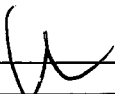



Date: Friday, 06/03/2009 8:50:37 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STOP
 Job Number : 46314
 Estimate Number : 10513
 P.O. Number :
 This Issue : 06/03/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D28052
 Drawing Number : D2805 REV. B
 Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 41707 Material :
 Due Date : 13/03/2009 Qty: 12 Um: Each
 Written By : 
 Checked & Approved By : 
 Comment : Est: B 00.11.14 Revised Finishing step to Acid etch and Alodine EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B1500X01500	6061-T6 Bar 1.50 x 1.50
-----	--------------------	-------------------------



Comment: Qty.: 0.2756 f(s)/Unit Total: 3.3075 f(s)

6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5"

(M6061T6B1500X01500)

Batch: M108962

G.A 09/03/11

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut Bar: 3.150" Long +0.010/-0.030"

G.A 09/03/11

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA104 and Dwg D2805

2- Tumble and Deburr

Identify as D2805-2

J.L 09/03/12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 09/03/12

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.L 09/03/12

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 06/03/2009 8:50:38 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 46314

Part Number: D28052

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

CMO/BL

09/03/12

(12)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

09-02-12

(12)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: UB

9/3/13

SP

(12)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/15

(12)

Job Completion



MF
09-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

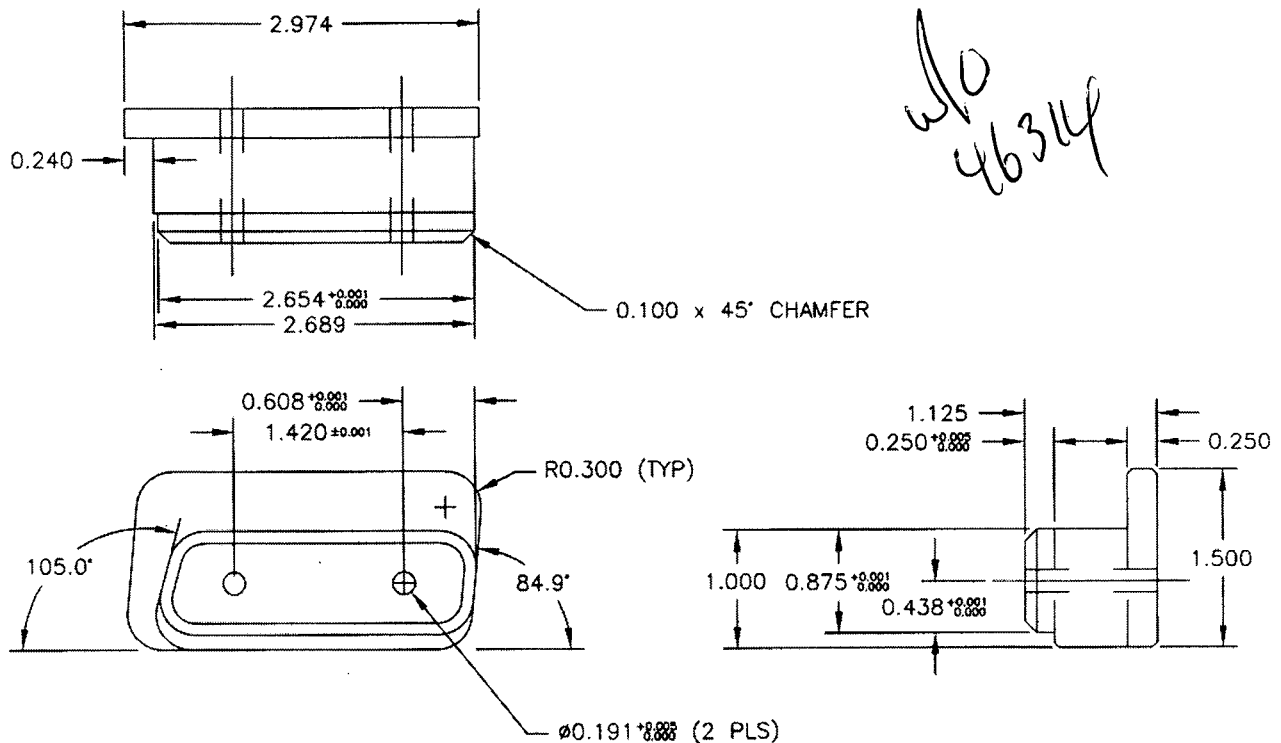
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
01.03.16 #



D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

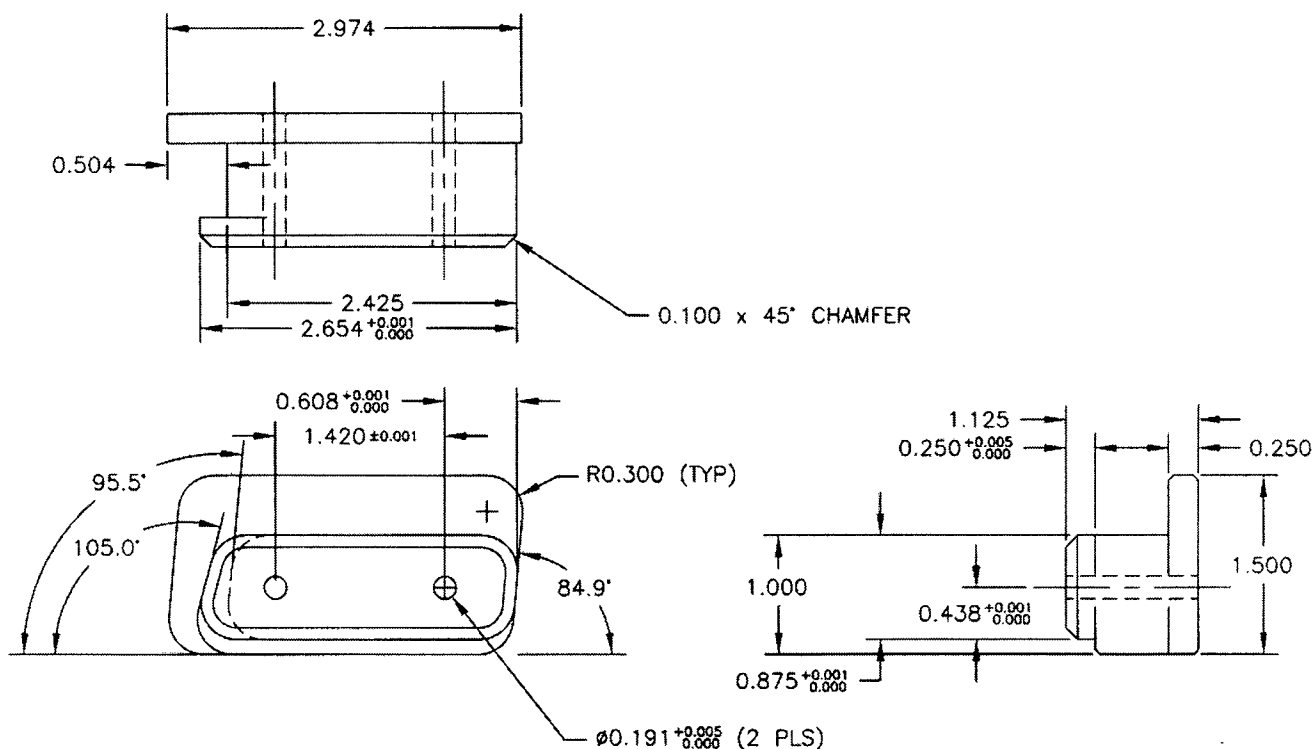
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN [Signature]	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED
010316



D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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